

Work Order ID 88695

88695

Page 1

July-30-12 3:55:19 PM

Item ID: D2896-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 30/07/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 13/08/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/30 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2896

C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA167

Folio Rev: 44

Dwg Rev: 0

0.00

Deburr

****Program Batch #*****

110

0.00

110

QC1- Inspect dimensions to dimension sheet

QC

Quality Control

Memo

0.00

B.A. 12/08/27

20 ϕ

OK 12/08/28
B.A. 12/08/30

20 ϕ

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 88695

88695

Page 2

July-30-12 3:55:19 PM

Item ID: D2896-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Support

Stop *NS2*

Start Date: 30/07/2012 Start Qty: 20.00 *20*

Cust Item ID:

Required Date: 13/08/2012 Req'd Qty: 20.00 *20*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				26			
Quality Control									
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

20 20 12/9/05

12/9/5

1209-5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION <div style="display: flex; justify-content: space-around;"> <div>Rework <input type="checkbox"/></div> <div>Skid-tube <input type="checkbox"/></div> <div>Crosstube <input type="checkbox"/></div> <div>Water Jet <input type="checkbox"/></div> <div>Engineering <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Scrap <input type="checkbox"/></div> <div>Machining <input type="checkbox"/></div> <div>Small Fab <input type="checkbox"/></div> <div>Prod. Eng. Coord. <input type="checkbox"/></div> <div>Quality <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Use-as-is <input type="checkbox"/></div> <div>Thermoforming <input type="checkbox"/></div> <div>Finishing <input type="checkbox"/></div> <div>Rec/Store/Packaging <input type="checkbox"/></div> <div>Other <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Work Order Update <input type="checkbox"/></div> <div>Large Fab <input type="checkbox"/></div> <div>Composite <input type="checkbox"/></div> <div>Supplier <input type="checkbox"/></div> </div>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
<div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"> <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge </div> <div style="width: 30%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other </div> </div>		

Picklist Print

July-30-12 3:55:23 PM

Page 1

Work Order ID: 88695

88695

Parent Item: D2896-1

D2896-1

Parent Item Name: Support

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ
 IPP Rev:C As per Rev B 07-04-16 JLM
 IPP D 08.03.19 Re-format EC verified by DD IPP REV:E
 11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK080		Manufactured	No			100	Each	12.0000	0.5	10			

DSK080
 D2896-1 TURNING DETAIL

**

Location	Loc Qty	Loc Code
MAT060	12	
→ 73927	4	
→ 82953	8	

2
8

mk 12/08/24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced
<input type="checkbox"/>	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld
<input type="checkbox"/>	Crushed/Crimped	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved		
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	Other
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge		
<input type="checkbox"/>	Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset				
<input type="checkbox"/>	Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration				
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence				
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions				

DART AEROSPACE LTD		Work Order:	88695
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.171	2.157	2.165	2.164	2.169
AB	2.340	2.360		2.350	2.350	2.353	2.354	2.349
AC	3.550	3.560		3.554	3.555	3.554	3.555	3.552
AD	3.770	3.790		3.786	3.787	3.783	3.784	3.780
AE	0.065 x 0.315	0.085 x 0.335		0.070x315	0.072x321	0.078x319	0.071x325	0.072x315
AF	1.42	1.48		1.450	1.445	1.450	1.447	1.447
AG	0.833	0.853		.847	.846	.847	.848	.844
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.262	.262	.263	.263	.262
AJ	0.189	0.194		.192	.191	.192	.192	.192
AK	1.970	2.030		2.000	2.000	1.999	2.002	1.998
AL	0.625	0.630		.6257	.6255	.625	.6255	0.6257
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.945	.945	.943	.943	.939
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.001	.001	.003	.0005	.001

Measured by:	my	Date:	12/08/28
Audited by:	F.K. RP	Date:	12/09/01
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

DART AEROSPACE LTD		Work Order:	88695
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/6	2/7	3/8	4/9	5/10
HAAS Section								
AA	2.152	2.172		2.171	2.163	2.171	2.170	2.167
AB	2.340	2.360		2.353	2.353	2.355	2.350	2.350
AC	3.550	3.560		3.553	3.553	3.553	3.551	3.553
AD	3.770	3.790		3.780	3.779	3.782	3.780	3.779
AE	0.065 x 0.315	0.085 x 0.335		.073X.318	.075X.320	.072X.315	.070X.315	.076X.321
AF	1.42	1.48		1.442	1.448	1.446	1.447	1.441
AG	0.833	0.853		.851	.842	.845	.842	.842
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.262	.262	.262	.262	.262
AJ	0.189	0.194		.192	.192	.192	.192	.192
AK	1.970	2.030		2.000	2.005	2.004	1.999	2.000
AL	0.625	0.630		.6257	.6257	.6257	.6257	.6257
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.942	.944	.943	.944	.939
AP								
AQ								
AR								

Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"

Accept/Reject	.0015	.000	0.002	0.0002	0.0004 (0.001)
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Measured by: *cmx / b.g.* Date: 12/08/29

Audited by: *F.K. RP* Date: 12/09/01

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
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D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	88695
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				/1	/2	/3	/4	/5
HAAS Section								
AA	2.152	2.172		2.169	2.169	2.1715	2.166	2.160
AB	2.340	2.360		2.350	2.352	2.355	2.354	2.355
AC	3.550	3.560		3.554	3.553	3.555	3.554	3.555
AD	3.770	3.790		3.781	3.783	3.779	3.780	3.784
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.330	0.075 x 0.330	0.075 x 0.328	0.075 x 0.325	0.075 x 0.325
AF	1.42	1.48		1.450	1.448	1.447	1.447	1.447
AG	0.833	0.853		0.844	0.845	0.847	0.846	0.848
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.262	0.262	0.261	0.261	0.261
AJ	0.189	0.194		0.192	0.192	0.191	0.191	0.191
AK	1.970	2.030		2.000	2.000	2.001	2.001	2.001
AL	0.625	0.630		0.6257	0.6257	0.6257	0.6257	0.6257
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.945	0.941	0.9435	0.943	0.945
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				0.000	0.001	0.0005	0.0005	0.001

Measured by: *[Signature]* / J.A. 12/08/30 **Date:** 12/08/29

Audited by: *[Signature]* F.K. **Date:** 12/09/01

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	28695
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

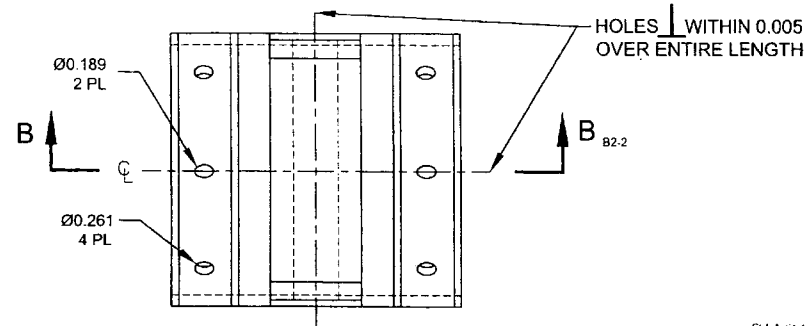
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#6	#17	#18	#19	#20
HAAS Section								
AA	2.152	2.172		2.1695	2.1675	2.169	2.167	2.166
AB	2.340	2.360		2.353	2.357	2.357	2.357	2.358
AC	3.550	3.560		3.555	3.554	3.554	3.556	3.557
AD	3.770	3.790		3.773	3.775	3.773	3.783	3.785
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325	0.075 x 0.325
AF	1.42	1.48		1.447	1.447	1.447	1.447	1.447
AG	0.833	0.853		0.845	0.846	0.846	0.847	0.847
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.260	0.260	0.260	0.260	0.260
AJ	0.189	0.194		0.191	0.191	0.191	0.191	0.191
AK	1.970	2.030		2.000	1.998	2.013	1.998	2.001
AL	0.625	0.630		0.6257	0.6257	0.6257	0.6257	0.6257
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.9445	0.9445	0.9455	0.946	0.9445
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				0.001	0.001	0.001	0.0025	0.0005

Measured by:	M.A.	Date:	12/08/30
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Audited by:	E.K. RP	Date:	12/09/01
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Preliminary Approval:		Date:	
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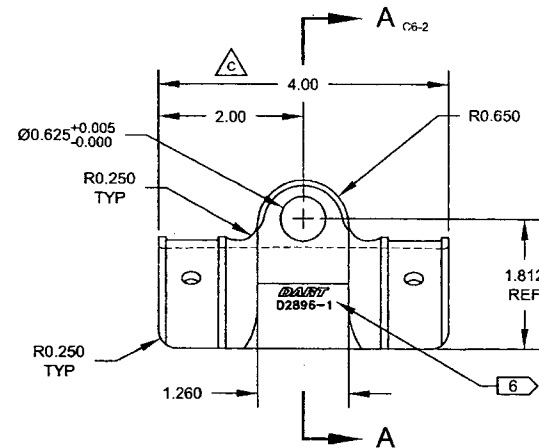
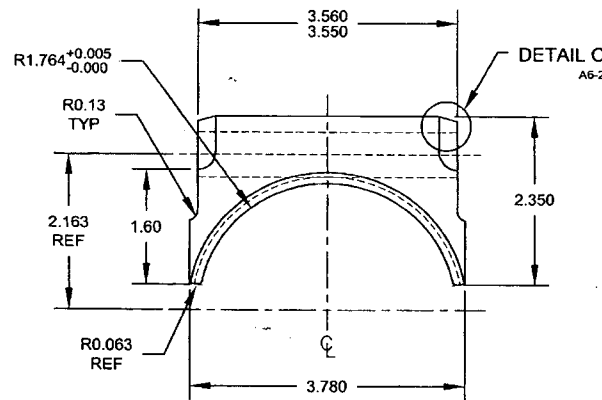
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	



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NO. 88695 MLC

12/07/30

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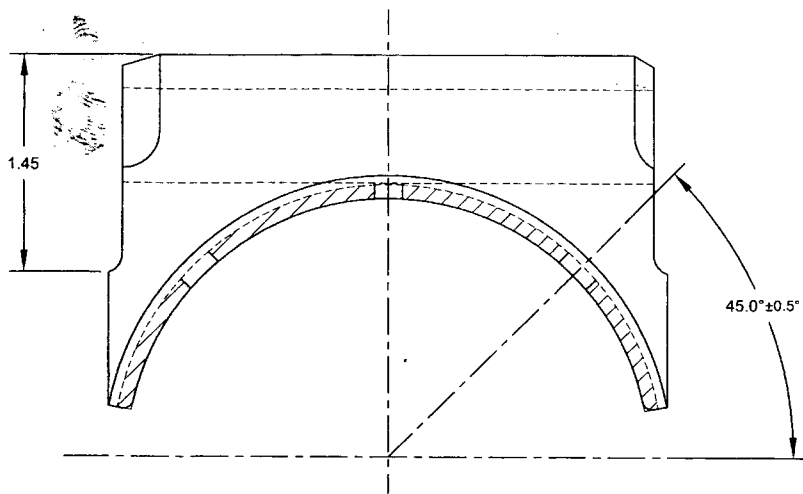
D2896-1 SUPPORT

NOTES:

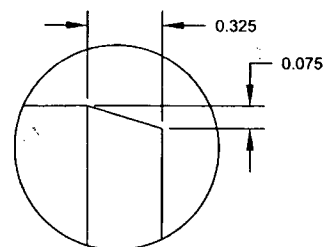
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	JP	D2896	SHEET 1 OF 2
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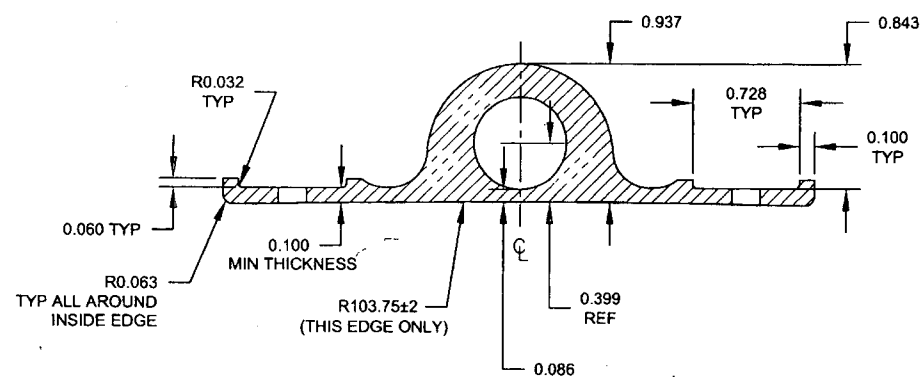
2269



SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



DETAIL C C6-1
SCALE 4X



SECTION B-B D3-1
SCALE 2X

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CHECKED	ASS	DRAWING NO. REV. C
MFG. APPR.		D2896 SHEET 2 OF 2
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